

# Work Order ID 80059

\*80059\*

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February-09-12 12:46:06 PM

Item ID: D2432 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: 206 (24") Bearpaw  
 Start Date: 09/02/2012 Start Qty: 8.00  
 Required Date: 23/02/2012 Req'd Qty: 8.00  
 Reference: *\*8\* 5 sel w/o 63745A + PTO*  
 Cust Item ID:  
 Customer:

Approvals: Process Plan: M.L.J Date: 12/02/09 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2432	Rev F3

120 FLOW WATER JET 0.00  
**\*120\***  
 Waterjet Memo 0.00  
 FLOW CNC Waterjet Cut Blank as per D2432 File  
 (5) 12-2-21  
 (4)

130 HAAS CNC VERTICAL MACHINING #1 0.00  
**\*130\***  
 HAAS 1 Memo 0.00  
 HAAS CNC vertical machine #1  
 1-Inspect material for defects or damage prior to machining  
 2-Machine as per Folio and Dwg D2432 Identify as D2432F  
 3-Deburr  
 (5) 12-02-23  
 (PTO) →

140 QC2- Inspect parts off machine FAI/FAIB 0.00  
**\*140\***  
 QC Memo 0.00  
 Quality Control  
 (5) 12-02-23

W/O: 80059		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2432 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-01-23	170	4 of the D2432 been paws scribed as B63795 instead of B80059	U 12-02-23	re-issued w/o of 63795-A - u to sth	U 12-02-24	U 12-02-24	U 12-02-23	U 12-02-24

NOTE: Date & initial all entries

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 Required Date: 23/02/2012 Req'd Qty: 8.00 \*8\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
*150*									
QC	Memo	0.00							
Quality Control									
151	Identify as per dwg & Stock Location: _____	0.00							
*151*									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
*190*									
QC	Memo	0.00							
Quality Control									

M.A 12/02/26

5 0

5x SP12-02-27

12/2/27

PD-02-27  
(5)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 80059

\*80059\*

Parent Item: D2432

\*D2432\*

Parent Item Name: 206 (24") Bearpaw

Start Date: 09/02/2012

Required Date: 23/02/2012

Start Qty: 8.00

Required Qty: 8.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	668.5243	3.7	29.6	30,		
*MUHMWB10*										**	1312-2-21		
UHMW 1" Black													

### Location

### Loc Qty

### Loc Code

MAT018

408.88

120035

88.88

120401

320

MAT019

259.6443158

117321

74.6

117738

95.8

117819

83.3

118814

1.5

119145

4.44431579

120401

9

18  
17.77

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80059
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D2432
<b>Inspection Dwg:</b> D2432 <b>Rev:</b> F3		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.056	✓		vern	RT-4
B	5.500	+/-0.030	5.500	✓			
C	0.200	+/-0.030	.201	✓		depth gauge	RT-6
D	0.25 x 45°	+/-0.030	.260	✓		vern	RT-4
E	R0.250	+/-0.030	.250	✓		rad gauge	
F	0.250	+/-0.010	.244	✓		mic	118/20
G	0.625	+/-0.030	.632	✓		vern	RT-4
H	0.375	+/-0.010	.382	✓		mic	118/20
I	0.950	+0.030/0.010	.953	✓		vern	RT-4
J	19.000	+/-0.030	19.00	✓		Tape	RT-11
K	3.14	+/-0.030	3.132	✓		vern	
L	3.28	+/-0.030	3.305	✓		"	
M	Ø0.260	+0.005/-0.000	.260	✓		"	
N	Ø0.93	+/-0.030	.930	✓		"	
O	0.30	+0.030/-0.000	.306	✓		"	
P	23.750	+/-0.030	23.75	✓		Tape	
Q	7.375	+/-0.030	7.38	✓		vern	CNC-02
R	4.250	+/-0.010	4.254	✓		"	
S	2.000	+/-0.030	2.007	✓		"	
T	9.000	+/-0.010	9.006	✓		"	
U	9.000	+/-0.010	9.009	✓		"	
V	0.375	+/-0.010	.377	✓		"	

<b>Measured by:</b> RT	<b>Audited by:</b> BA	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12-02-23	<b>Date:</b> 12/02/26	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015 KJ/RF	RT

**Dart Aerospace Ltd**

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

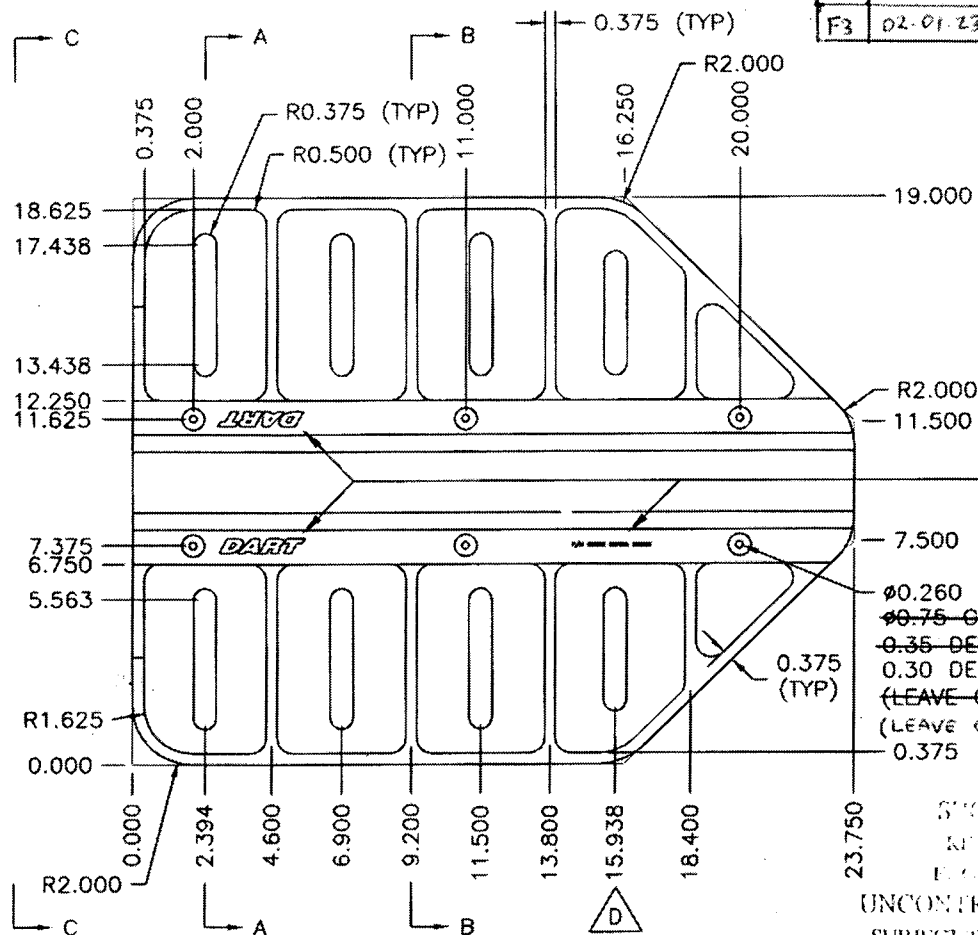


F1	99.03.03	ADD DEO 9143
F2	01.03.28	<del>Ø0.93 WAS Ø0.75</del> RF
F3	02.01.23	CLARIFY BORE DIMS RF

RELEASED  
93.06.17 KE



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



Ø0.260 (TYP)  
~~Ø0.75 C'BORE~~ Ø0.93 C'BORE  
0.35 DEEP FROM TOP (MIN.)  
0.30 DEEP FROM BOTTOM  
(LEAVE 0.300 MIN.)  
(LEAVE 0.650 MIN.)  
0.375

UNCONTROLLED COPY  
SUBJECT TO APPROVAL  
WITHIN THE  
WORK AREA  
NO. 80059

0.950 (REF)

EFFECTIVE DEOS

9143

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
MM	KE	D2432
DATE	TITLE	REV. F
98.05.12	BEARPAW	SHEET 1 OF 2
		SCALE
		1:6
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

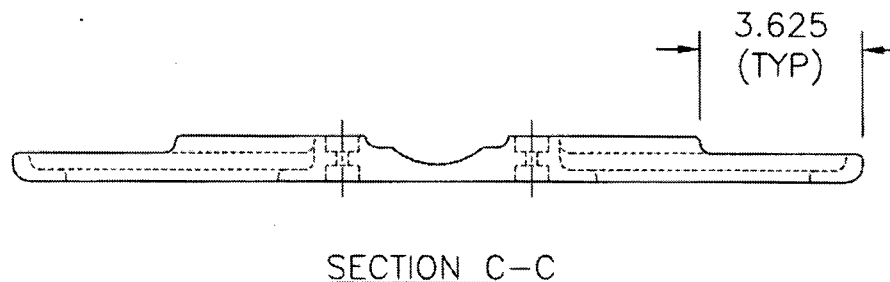
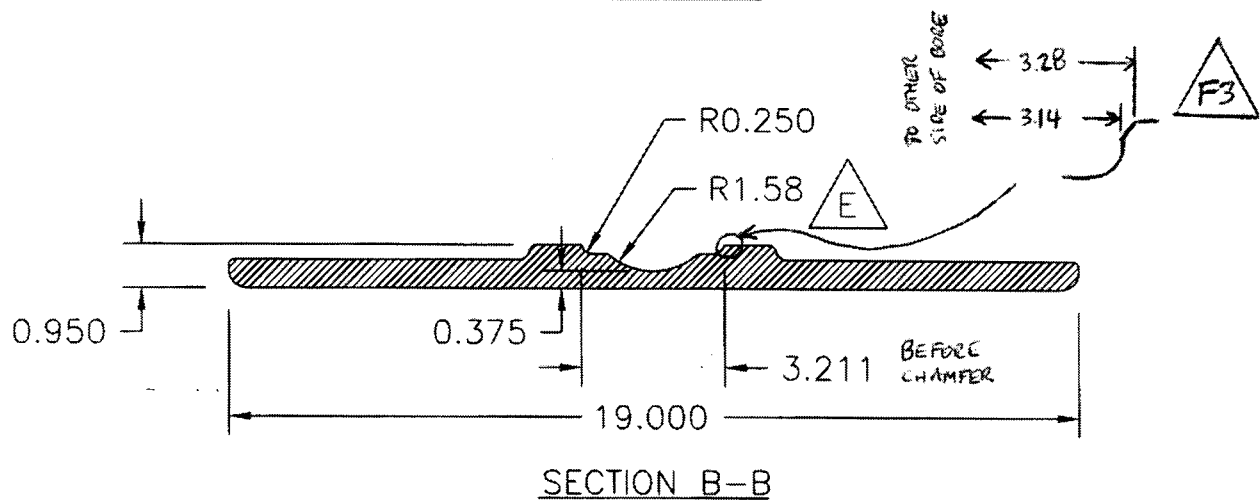
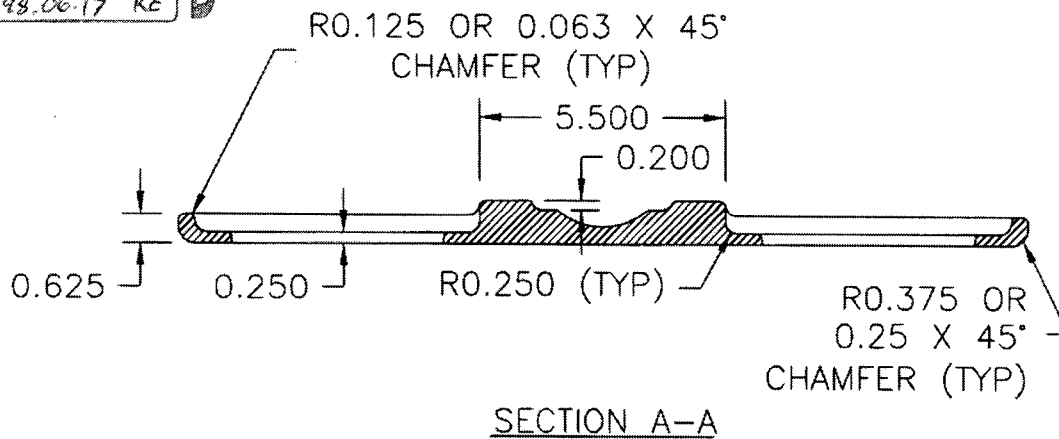
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED  
98-06-17 KE



0005

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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